

Product Data Sheet

Awlgrip HDT Clearcoat



Intended Uses

Awlgrip HDT Clearcoat is a revolutionary high gloss topcoat which is VOC compliant (VOC-420g/L). Awlgrip HDT Clearcoat gives a hard finish which can be repaired and polished.
Awlgrip HDT Clearcoat is designed to work as the final layer of a multi-part system using Awlcraft SE Basecoat. Awlcraft SE Basecoat imparts the colour and effect and is then topcoated with Awlgrip HDT Clearcoat to give gloss and protection. This combination forms a high performance, high gloss robust topcoat system.

Specification Data

Volume Solids	49% (mixed product)
Specific Gravity	0.98 - Base
Available Packs	1 US Gallon (=3.78L) for Base and Curing Solution 1 US Quart (=0.95L) for Activators
Base	Awlgrip HDT Clearcoat (OC0300)
Converter	Awlgrip HDT Curing Solution (OC0010)
Reducer	Activators: Awlgrip Slow Activator (OA0010) Awlgrip Fast Activator (OA0020) Activators are essential for the technology of this product to achieve the required curing.
Equipment Cleaning	T0001, T0002, T0003
Typical Shelf Life	2 years for Base and Activators 1 year for Curing Solution

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Compliant/RP Spray Gravity, Conventional Spray Gravity, Electrostatic	2	75 µm 3 mil	37 µm 1.5 mil		13.2 m ² /lt 537.8 ft ² /Gal

Coverage calculations are calculated for mixed base, curing solution and activators and are based on a theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size and application environment.
The total DFT can be reached in 2 to 3 coats depending on application.
Minimum DFT figures are post sanding.



VOC

All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC content may vary by batch and when tested via standard test methodology.
VOC values are for the mixed product and recommended mixed ratio.

Product	As Supplied (without reducer)			
	g/l	lb/gal	g/Kg	lb/lb
OC0300 Base	0	0		
Awlgrip HDT Clearcoat	420	3.51		



Surface Preparation

For the application of the basecoat please refer to the Awlcraft SE TDS.
Awlcraft HDT Clearcoat should be applied over Awlcraft SE Basecoat or previous Awlgrip/Awlgrip HDT/Awlgrip Topcoat. Over basecoat ensure the surface must be clean and dry. Wipe with surface cleaner T0170 (US) or T0340 (EU) using the two cloth wipe down method. Over Awlgrip Topcoat/Awlgrip HDT/Awlgrip 2000 topcoat sand topcoat with P400 to remove the gloss and clean with surface cleaner T0170 (US) or T0340 (EU) using the two cloth wipe down method.

Do not use unless mixed thoroughly with the curing agent at specified ratio. Avoid painting in direct sunlight. Substrate temperature should be minimum 5°C/41°F and maximum 30°C/86°F. Product temperature should be minimum 15°C/59°F and maximum 35°C/95°F. Ambient temperature should be minimum 5°C/41°F and maximum 30°C/86°F. Avoid applying late in the evening as condensation can cause a loss of gloss during overnight cure. Allow to dry in a well ventilated environment.

The surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary according to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale preparation.



Mixing & Reduction

Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full-scale application is recommended.

Mix Ratio (by volume):
1:1:0.25 (Base:Curing Solution:Activator)
Induction time = 15 minutes.
Mix to a smooth, homogenous mixture.
Awlgrip HDT Clearcoat is designed for spray application only. Correct choice of activator must be made according to the application conditions and project

Please refer to your local representative or visit <http://www.awlgrip.com> for further information.

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size.

General guideline:

- 15-23°C - OA0020

- 20-30°C - OA0010-OA0020 with a 50:50 mixture by volume

- >30°C - OA0010



Application

To apply Awlcraft SE Basecoat please refer to the Awlcraft SE TDS. To ensure optimal adhesion between coats Awlgrip HDT should be applied according to the overcoating intervals as described in the Recoatability & Drying Times section.

Apply a full coat of Awlgrip HDT Clearcoat to the surface. Allow tack coat to "flash off" 30-45 minutes depending on application conditions. Apply a slightly heavy second coat. A third coat can be applied to reach DFT if needed.

Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment condition and other factors. Testing on a non-critical area should be carried out prior to full-scale application. Contact your local technical service representative for further advice if necessary.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Conventional Spray Gravity, Electrostatic	1.20 - 1.40 mm 47 - 55 thou	-	180 - 280 cc/min	3 - 5 bar 44 - 73 psi
Compliant/RP Spray Gravity	1.20 - 1.40 mm 47 - 55 thou	-	180 - 280 cc/min	2 - 3 bar 29 - 44 psi



Recoatability & Drying Times

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings. If unsure, consult your local technical service representative before proceeding.

Drying	15°C (59°F)	23°C (73°F)	35°C (95°F)
Hard Dry	2 days	24 Hours	6 Hours
Touch Dry	20 Hours	17 Hours	3.5 Hours
Pot Life	3.5 Hours	2.5 Hours	1.5 Hours

Values in the table are for a 50:50 mix by volume of Awlgrip Fast Activator and Awlgrip Slow Activator. If using only Awlgrip Fast Activator or Awlgrip Slow Activator at a different ratio drying time and pot life will vary.

Awlgrip HDT Clearcoat has a shorter pot life than a standard polyurethane topcoat.

Overcoated By	15°C (59°F)		23°C (73°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Awlgrip HDT Clearcoat	2 Hours	3 days	30 Minutes	3 days	30 Minutes	3 days

The figures in this table refer to overcoating Awlcraft SE Basecoat with Awlgrip HDT Clearcoat.

Awlcraft SE Basecoat surface must be kept clean at all time before clearcoat application. To reduce dust contamination, clean compressed air or tack rags should be used over Awlcraft SE Basecoat. Oil contamination should be removed using light amounts of Awlgrip Wipe Down Solvent (NA/AP: Awlprep T0008; EU: Surface Cleaner T0340). In case of heavy contamination contact your local Representative.

Recoatability: Spray application consists of 2 to 3 coats applied over 2-4 hours. Exact time will vary with temperature, project size and film thickness applied. Awlgrip HDT clear cannot be overcoated with itself after 24h. Please contact your local representative for more information.

Some Important Points

Awlgrip HDT Clearcoat is compatible with Awlgrip repair product. Please refer to the Awlgrip Application Guide for further information.

Please refer to the Awlgrip Application Guide for information on maintaining Awlgrip HDT Clearcoat.



Warning Notes

The information in this Product Data Sheet is not intended to be exhaustive. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk and, to the extent permitted by law, we can accept no responsibility for the performance of the product or for any loss or damage arising out of such use. The information contained in this Product Data Sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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